

Work Order ID 73668

Monday, September 12, 2011 2:51:21 PM



Page 1

Item ID: D2891-1

Accept



Setup Start



Revision ID:

Stop



Item Name: 2.25 Support

Start Date: 9/12/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 8.00



Customer:

Reference: REWORK

Approvals: Process Plan: *ME*

Date: 11-09-12 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2891

B

190

0.00



HandFXtube

Memo

0.00

Hand Finishing Crosstubes

PULL FROM STOCK D2891-1 X 8
B28792 X 2, B 34062 X 6

STRIP OFF EXISTING PAINT

ME 11.09.14 (8)

200

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

BT 11.09.15 (X8)

210

0.00



HandFinish

Memo

0.00

Hand Finishing

Per note 8 on page 1 of dwg D2891, Prep inner concave surface of support and
apply 3M Scotch-Weld as per dwg.
24H of cure time.

ME 11.09.15 (8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

RT 11-09-20 (x8)

230

0.00



Packaging

Memo

0.00

Packaging

ID AND STOCK UNDER NEW BATCH NUMBER

USE ON ORIGINAL CROSSTUBES FROM HONG KONG
(36375, 36374,, 36378, 38508)

11-09-20 (8)

240

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/2011

11-09-20 (8)

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NOTES:

1) MATERIAL: 17-4 PH STAINLESS STEEL, H900 OR H925 CONDITION
MIN UTS = 170 KSI (38 HRC)
(REF DART SPEC. D6104)

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 (REF X.XXX = ± 0.010) UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

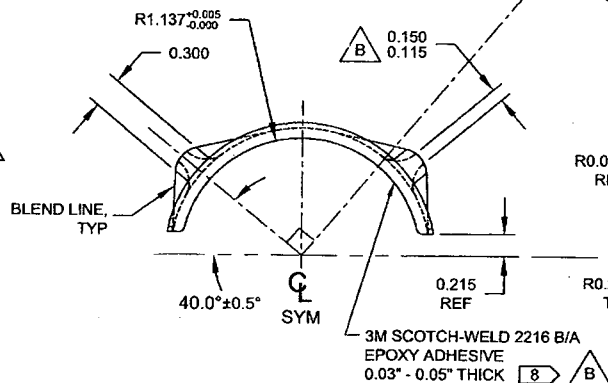
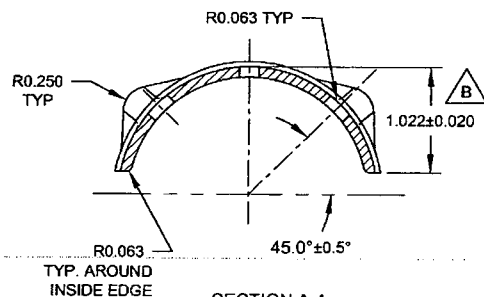
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING
0.010-0.020 DEEP, PER DART QSI 044 6.3.

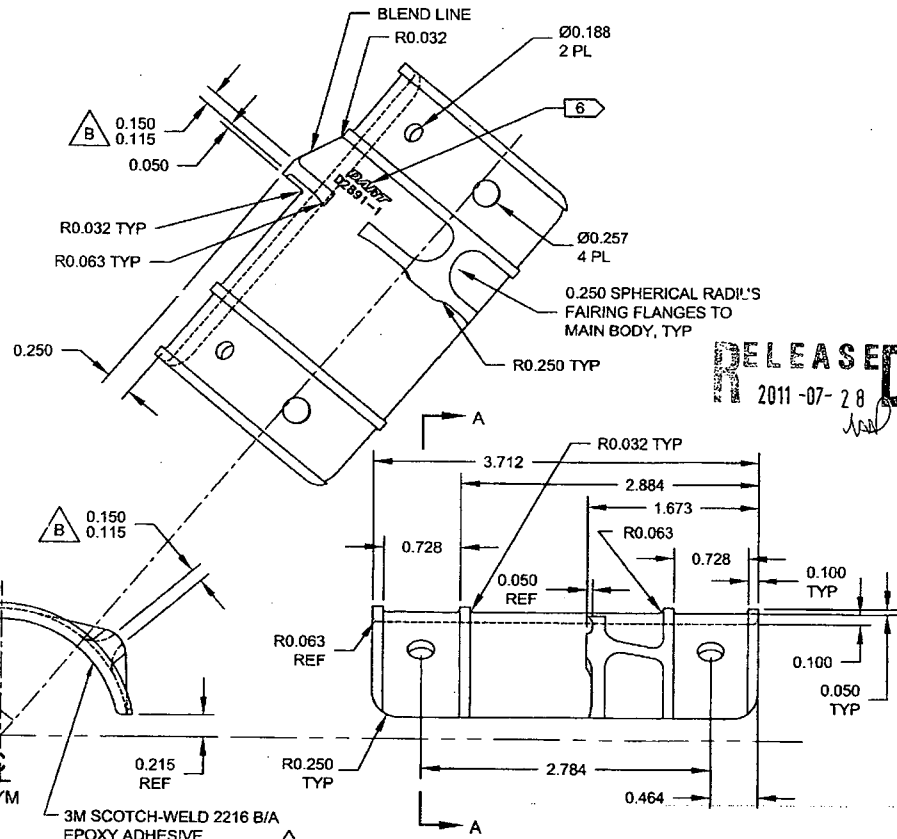
7) WEIGHT: 0.38 lb

8) FOR THE ENTIRE INNER CONCAVE SURFACE:
ABRADE SURFACE WITH 400-GRIT SANDPAPER. REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY 0.03" TO 0.05" THICK LAYER OF 3M SCOTCH-WELD 2216 B/A ADHESIVE TO MATING SURFACE OF SUPPORT. ALLOW TO CURE FOR 24 HOURS.





73668



D2891-1 SUPPORT



RELEASED
2011-07-28

B	RMV FINISH, ADD 3M 2216, ADD H925 MAT'L OPTION, UPDATE TOLERANCE (ZN D4-1,B4-1,B6-1)	CP	11.07.15
A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D2891	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		Ø2.250 SUPPORT	NTS
DATE	11.07.15	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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